

Work Order ID 54730 - 2

December 17, 2009 11:34:45 AM

split



Page 1

Item ID: D3929-042 *HA*

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *HA*

Date: *07-12-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3929

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *L*

2-Deburr if necessary

HB 10-1-4

9

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 10-1-4

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

=> 8 10/01/09

(49) /

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

~~PD 09.01.05~~
PD 10.01.08

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch M109213


M109213

~~PD 10.01.05~~ (6)
PD 10.01.08 (3)

pro ->

W/O: 54730

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		w/o was split due to extras were made 6 parts on original and 3 parts on this w/o					

Part No: D3929-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 10/01/12 ~~*Pl 10/01/05*~~

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/01/12
~~*SS 10/01/06*~~

(X3)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Basket cell

Memo

0.00

Packaging

SY 10/01/12 *(3x)*

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Page 4

Item ID: D3929-042

Accept



Setup Start



Revision ID:

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Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Required Date: 23/12/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14

MF 10-1-13

Picklist Print

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Page 1

Work Order ID: 54730

Parent Item: D3929-042

Parent Item Name: Gusset Assembly

Comments:

Start Date: 17/12/2009

Required Date: 23/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

107.0791

2.8421

4.3

13 10-1-4



304/316 0.125 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

107.0791

112663

107.0791

130

Each

57.0000

12.0000

112663

D3907-1

Manufactured

No



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

53673

17

~~5 PD 10.01.05~~

Main Warehouse

WA

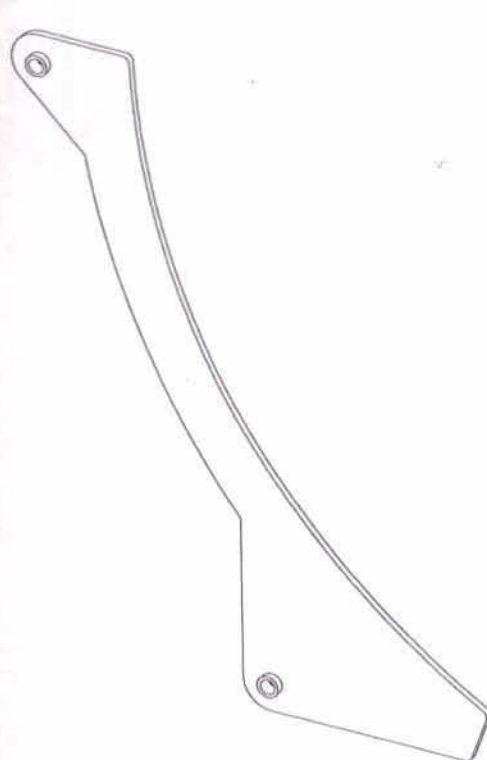
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54042

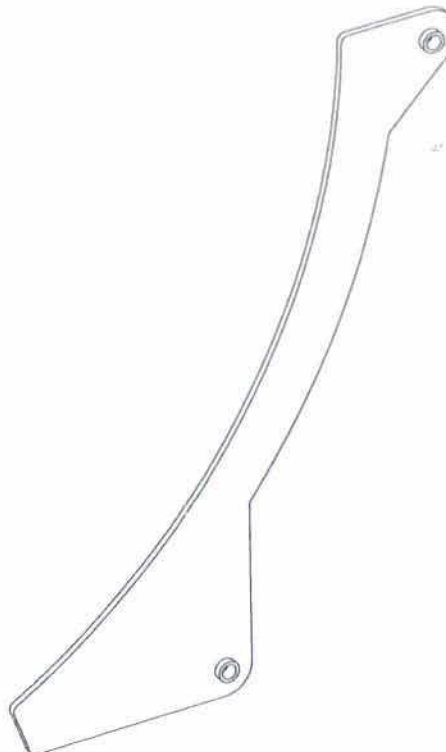
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~~5 PD 10.01.05~~

6 PD 10.01.08



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

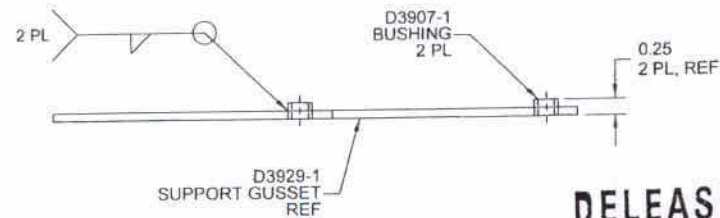
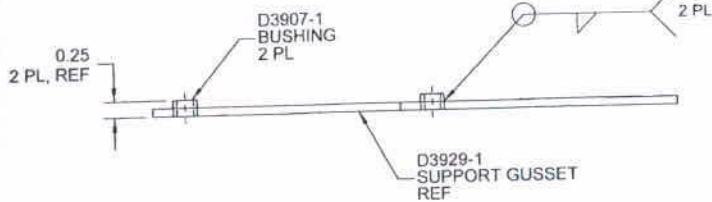
RELEASED
27/04/12 MB

W/O 54730

A	NEW ISSUE	MB	09.04.03
REV	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3929	SHEET 1 OF 3
MFG APPR.		TITLE	SCALE
APPROVED		GUSSET ASSEMBLY	NTS
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DATE	09.04.03		

D3929-1
SUPPORT GUSSET
2 PL

D3929-1
SUPPORT GUSSET
2 PL

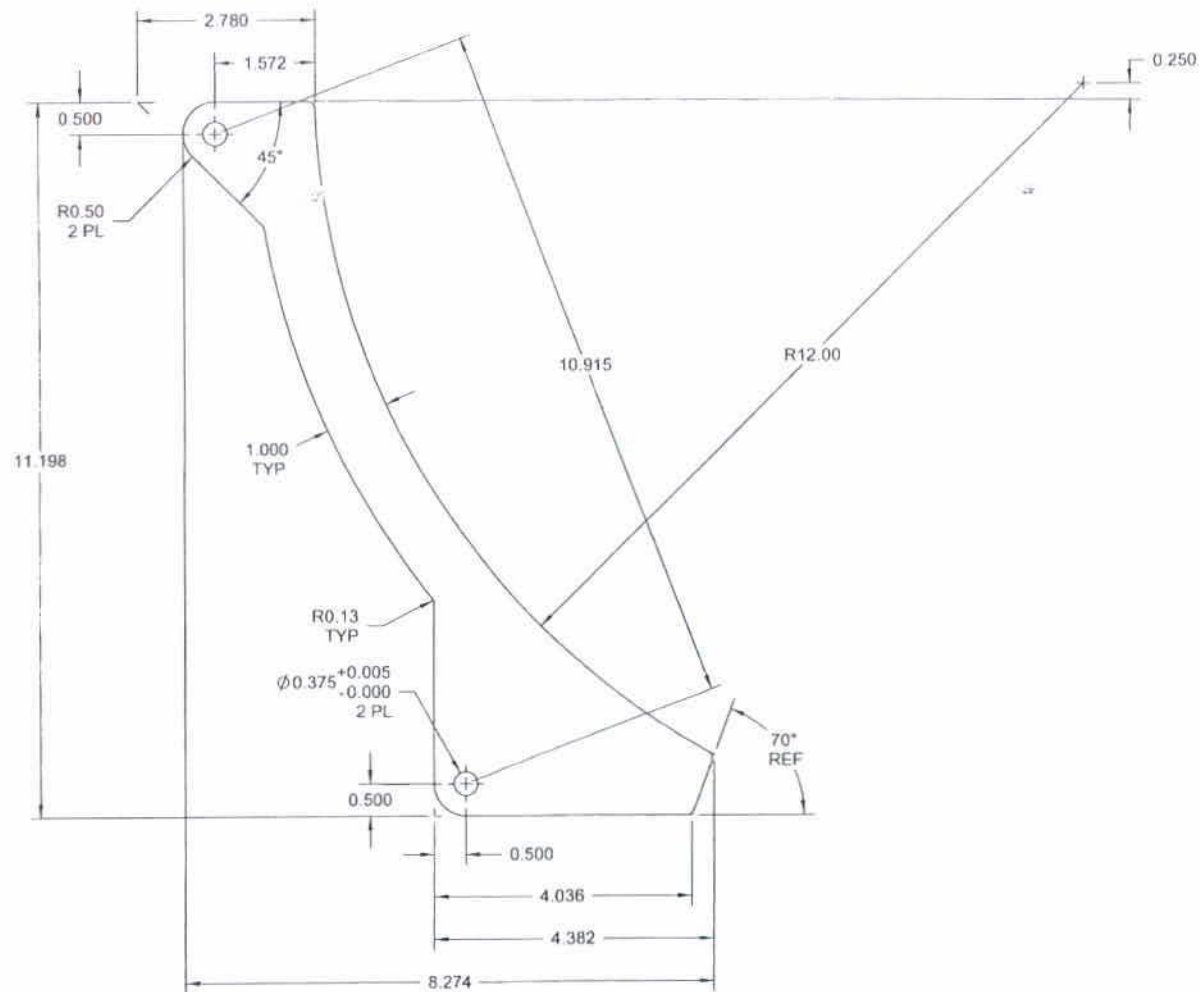


D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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(9/04/03)

W/0 54730